

A2 an adjustable pressure regulator included in said compressed air supply, said pressure regulator controlling the speed and force of said vibration device.

A3  
cont'd 2. (Amended) The apparatus according to claim 1 wherein said vibration device is a ball vibrator.

A3 5. (Amended) The apparatus according to claim 2 wherein said mold segments and top core cooperate to define a wheel mold cavity shape for casting a one piece vehicle wheel.

6. (Amended) The apparatus according to claim 2 wherein said mold segments and top core cooperate to define a wheel mold cavity shape for casting a full face wheel disc.

sub no 7. (Amended) The apparatus according to claim 1 wherein said vibration device is a reciprocating hammer.

A4 10. (Amended) A method for forming a vehicle wheel component casting comprising the steps of:

sub B3 (a) providing a multi-segment mold having a top core for casting the wheel component, the top core having a pneumatically powered vibration device mounted adjacent thereto, the vibration device being selectively operable to vibrate the mold top core;

(b) filling the cavity of the wheel component mold with a charge of molten metal;

(c) supplying compressed air to the vibration device to vibrate the top core upon completion of the filling of the mold cavity with molten metal for a portion of the time required for the molten metal to solidify;

(d) shutting off the supply of compressed air to the vibration device after the portion of the time required for the metal to solidify has elapsed;

14 (e) allowing the metal in the mold cavity to continue to cool until the metal is solidified;

15 (f) opening the mold; and

15 (g) removing the wheel component casting from the mold.

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16. (Amended) The method according to claim 14 wherein the multi-segment mold provided in step (a) forms a one piece vehicle wheel.

17. (Amended) The method according to claim 14 wherein the multi-segment mold provided in step (a) forms a full face wheel disc.

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Cancel claims 3, 4, 8, 9, 11 and 12.